
Wednesday, September 09, 2009 11:36:40 A



Stop

Abstract

[illegible][illegible]

Customer:

Run Start

Date: _____

[illegible]

Date:

SPC (Y/N):

Date:

Stop



100	FLOW WATER JET	0.00	
Waterjet	Memo	0.00	
FLOW CNC Waterjet	1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary		HB 9-9-24
304 040			(13)
110	QC2- Inspect parts off machine FAI/FAIB	0.00	
QC	Memo	0.00	HB 9-9-24
Quality Control			
120	QC8- Inspect parts - second check	0.00	
QC	Memo	0.00	2) 8/21/24
Quality Control			(13) 4

Work Order ID 51927

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Page 2

Item ID: D3535-25

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearshoe

Start Date: 9/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

NC BRAKE

0.00

Memo

0.00

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326
Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

SB 09/09/25

13

0

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) S 09/09/25

13

0

Quality Control

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: 320 °F □ OVEN TEMPERATURE:

2:00 □ FINISH TIME:

2:30

M 10/09/25

m-h 09/09/25

13X

Work Order ID 51927

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Page 3

Item ID: D3535-25

Accept

Revision ID: B

Item Name: Wearshoe

Start Date: 9/11/2009 Start Qty: 12.00

Required Date: 9/18/2009 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

0.00

Memo



QC

Quality Control

09/09/28

13

170

Identify as per dwg & Stock Location

0.00

0.00

Memo



Packaging

Packaging

09/10/28

X13

180

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo



QC

Quality Control

09/10/28

09/09/28

Picklist Print

Wednesday, September 09, 2009 11:36:46 AM

Page 1

Work Order ID: 51927



Parent Item: D3535-25RevB



Parent Item Name: Wearshoe

Start Date: 9/11/2009

Required Date: 9/18/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	245.8640	6.4421	7.000		



304/316 .040 Sheet



B9-924

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

245.8640474

110076

31.73

111571

22.1340474

112567

192

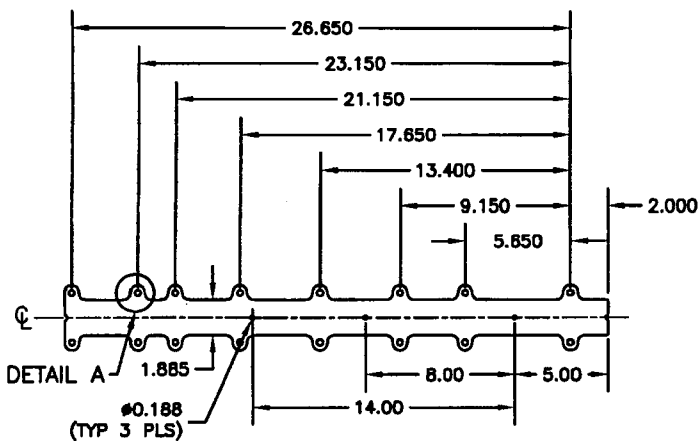
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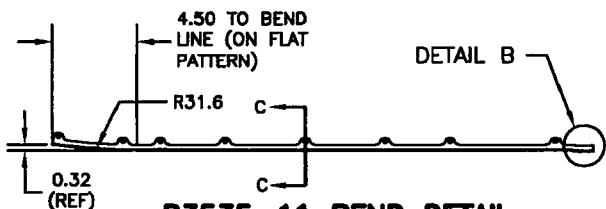
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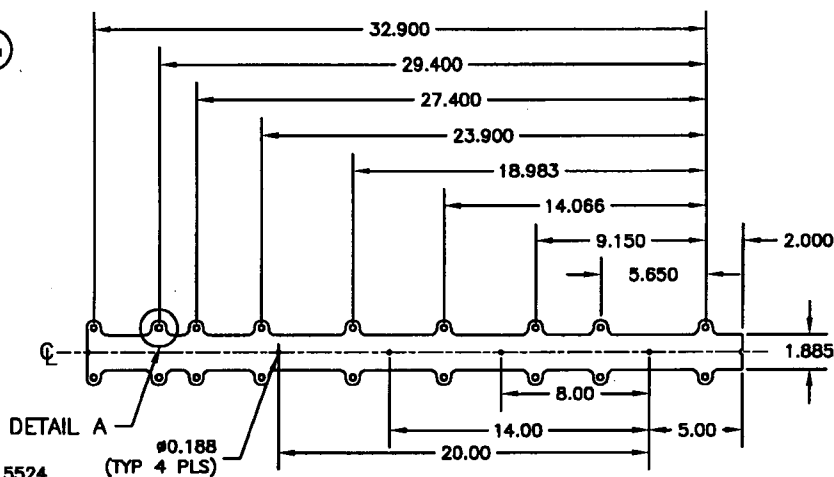
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WORK ORDER
NO. 31927



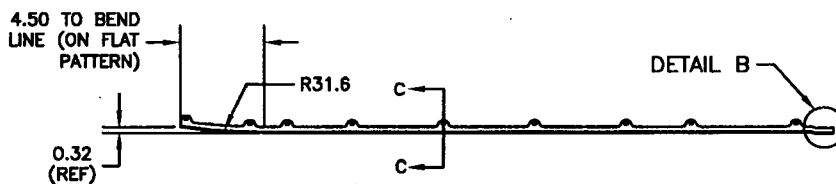
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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		D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

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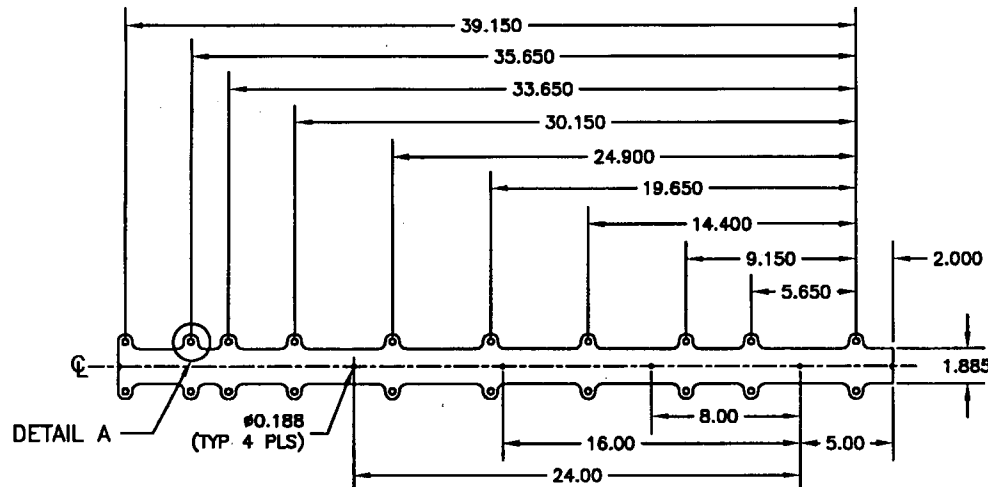
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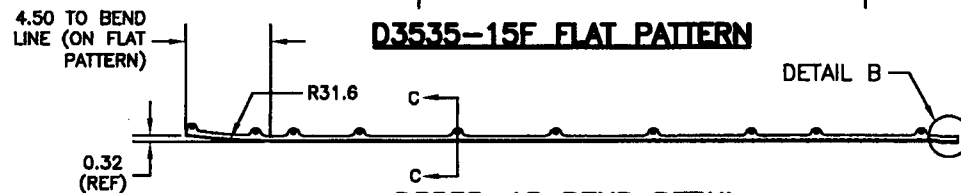
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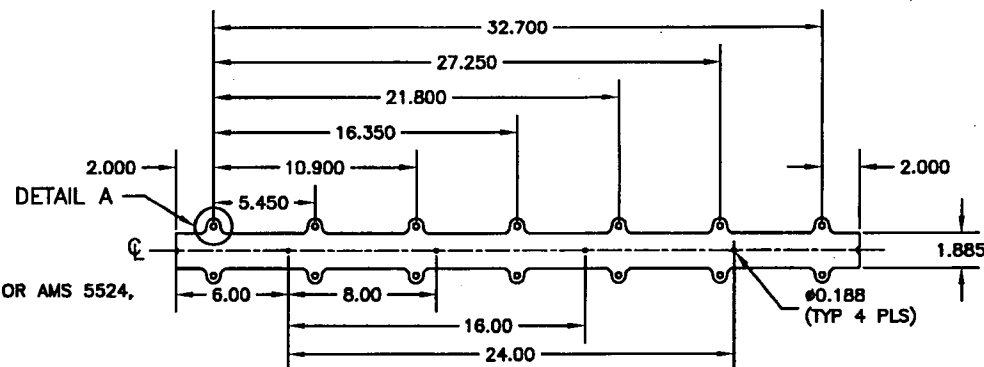
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		SCALE	1:10	



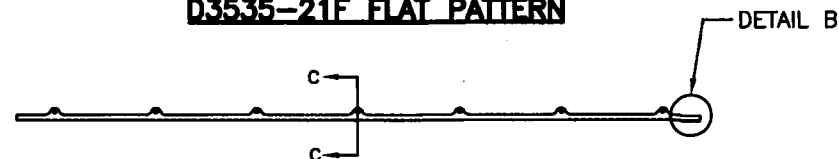
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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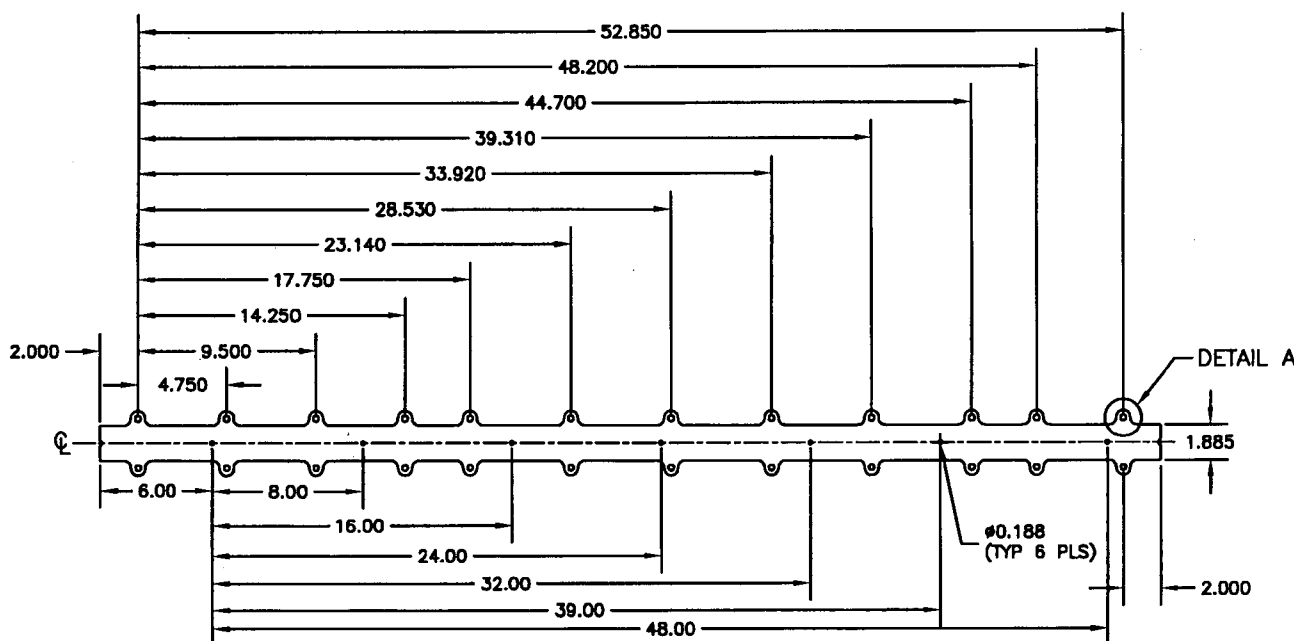
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wp 51927

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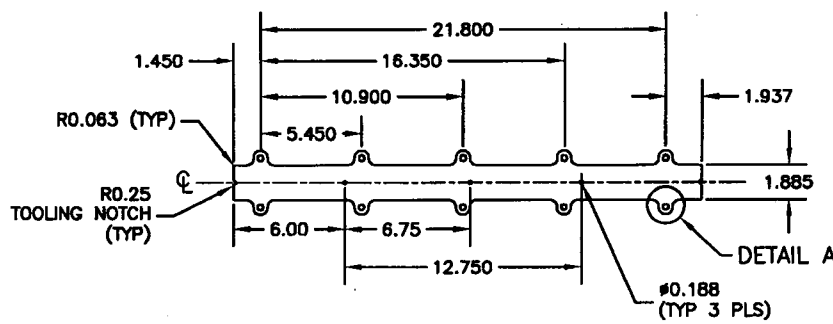
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		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

NOTES

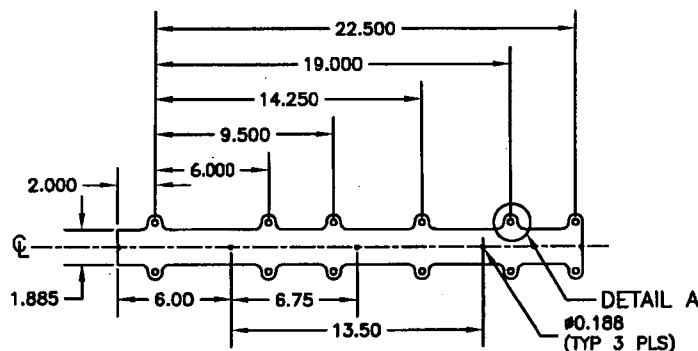
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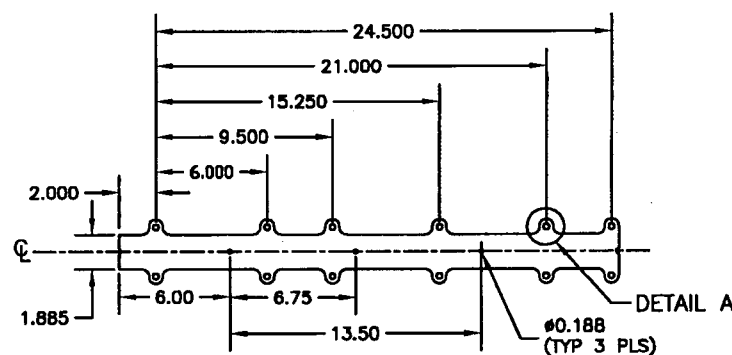
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN

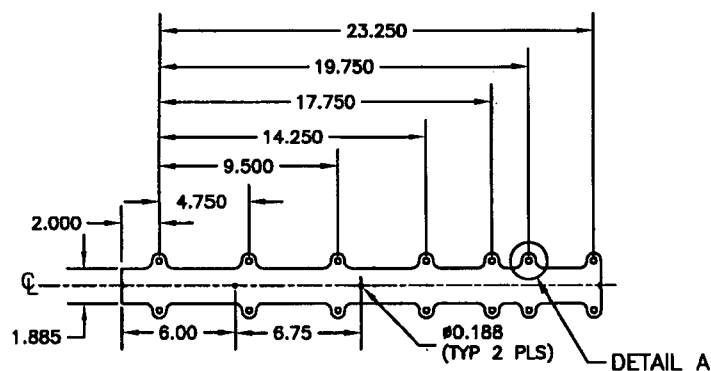
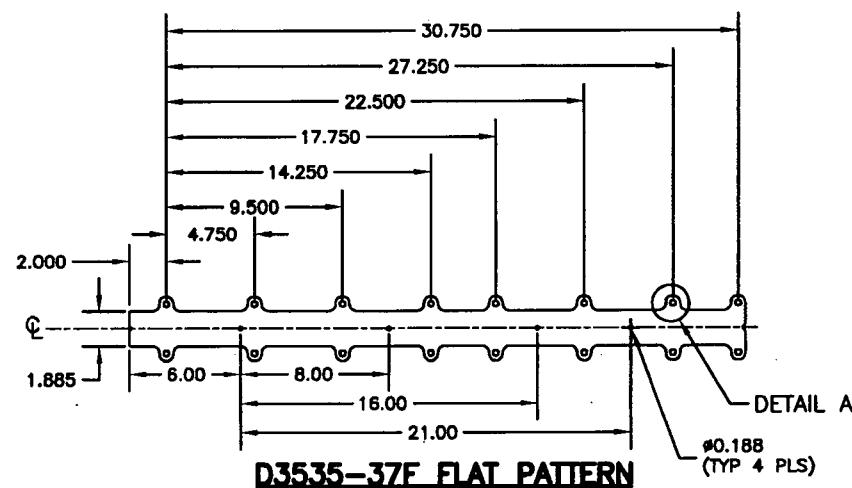


D3535-33 BEND DETAIL

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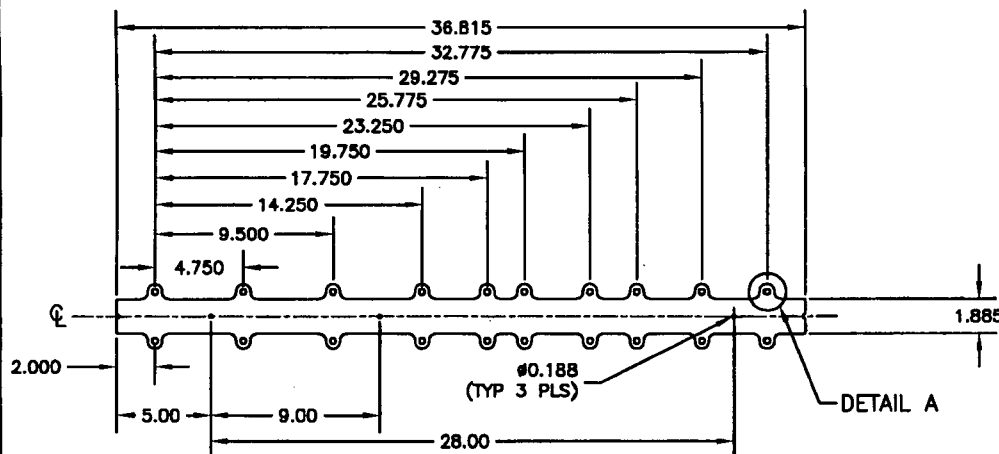
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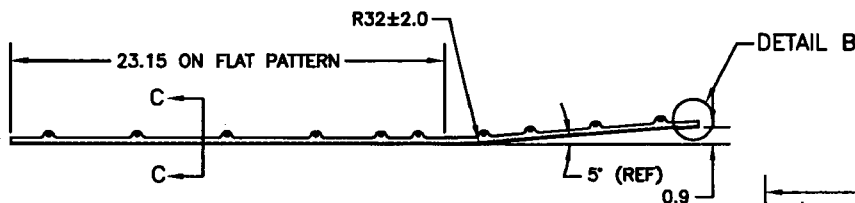
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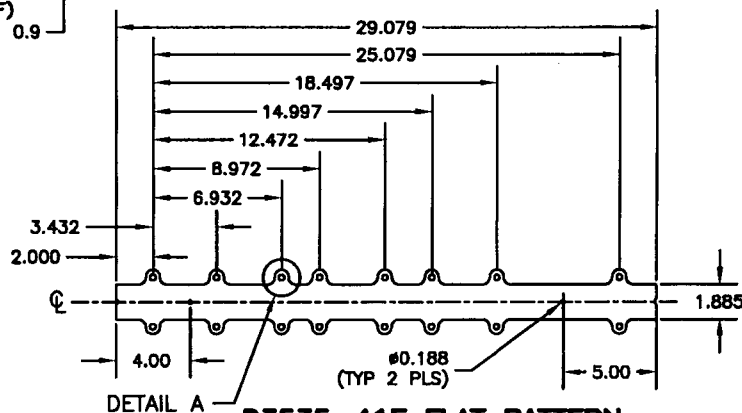
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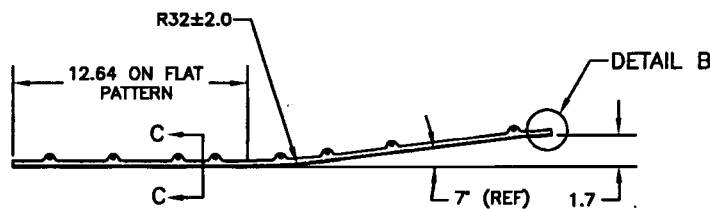
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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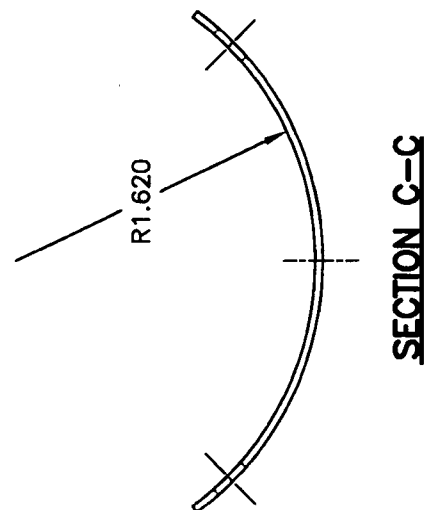
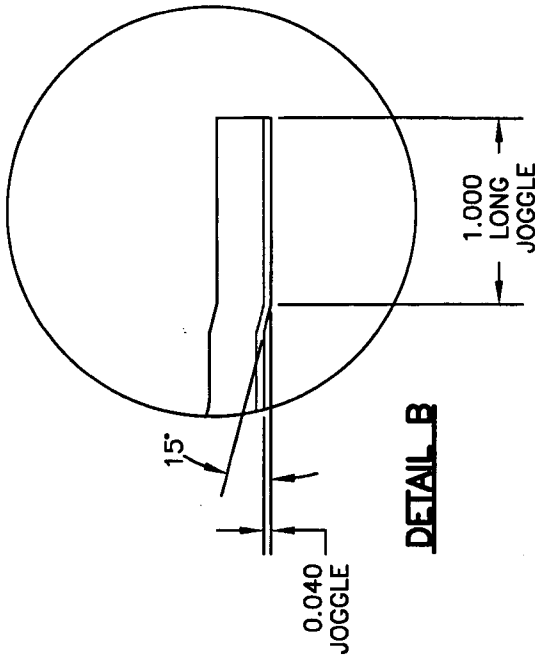
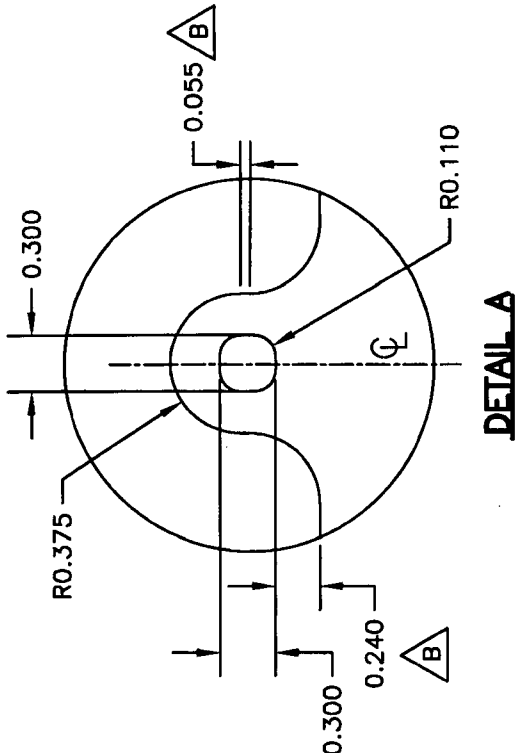
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